

Date: Tuesday, 13/05/2008 11:08:48 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG		
Job Number	: 39240			Part Number	: D2591		
Estimate Number	: 10008			Drawing Number	: D2591 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/05/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 05/06/2008 Qty: 100 Um: Each		
Previous Run	: 38441						
Written By	:						
Checked & Approved By	: JUO 08.5.13						
Comment	: Est Rev:l Removed from 9 Digit 05-10-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.2340 f(s)/Unit Total : 23.4000 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M108090	23.4 88 08/05/22
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.700" long	8.8 08/05/22 100
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		RG Comment: HAAS CNC VERTICAL MACHINING #1 machine per dwg D2591 REV. D 1- Machine as per Folio FA 039 and Dwg D2591 2- Deburr if required	RG 08/05/22 100
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE read + inspect for transit damage ensure CFC attached	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	PO 08/11/12 100
5.0	QCB	SECOND CHECK	
		Comment: SECOND CHECK inspect level 5	8 08/06/12 110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PC 8/6/13*

*(150)*

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.06.13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39240
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

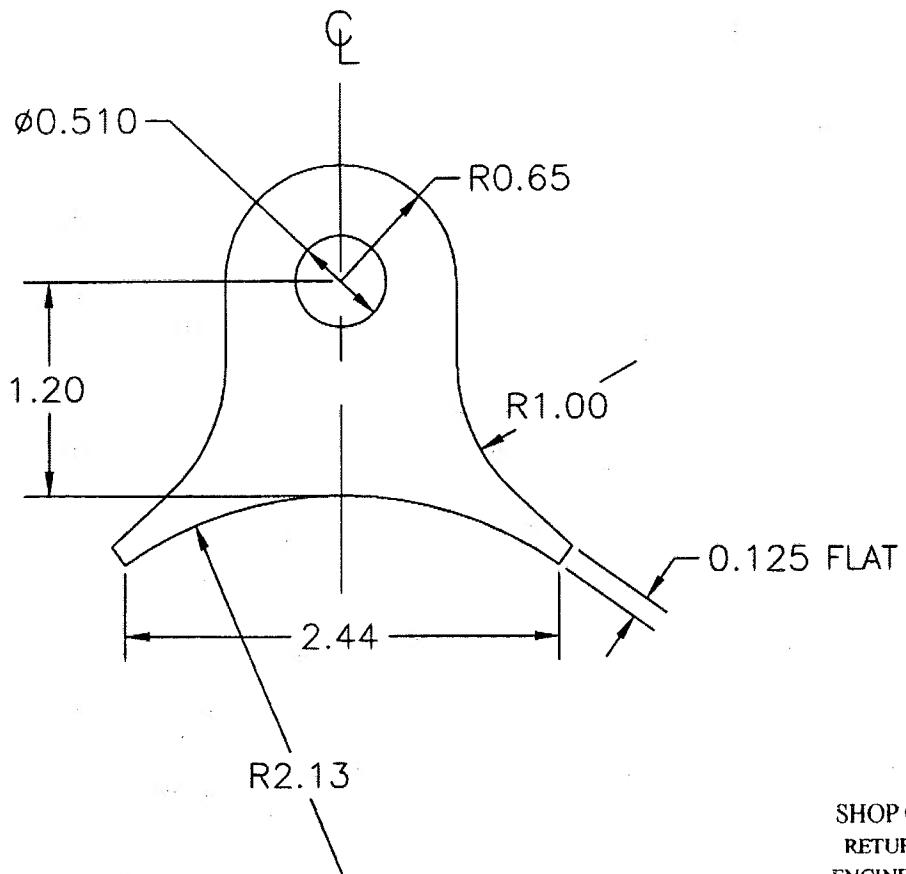
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DSI 9161-011	KJ/JLM	✓

**DART**

DESIGN <i>DNOY</i>	DRAWN BY <i>DNOY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21	TITLE GHW LUG		SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

**RELEASED**

98.01.21 DS



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 39240

*# 00.04.05*  
*0.063*

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2591	Lug B39240	6425
MATERIAL: supplied by DART M1010B0750X02500 M108090			

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Shig Walz".

Shig Walz

Vankleek Hill, June 10, 2008